



**S017322**



**Cross Bolt Spacer**

**Dart Aerospace Ltd.**

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**PART NO: D3490 - 1**

**Revision:**

**Operation: Start up Operation**

**Change No:**

**Mfg Date: 12/05/17**

**Job No: 168665**



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**D3490-1**

**Job Sheet 168665**



Part No: D3490-1

Job Qty: 80 ea

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/3/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 80 Ea  |            | 12/2/17  | 0.00      | 0.00    | Start Up Machining    |           |          |
| 100   | Hardinge           | 80 pcs |            | 12/3/17  | 0.00      | 6.50    | Hardinge              |           |          |
| 120   | QC                 | 80 pcs |            | 12/3/17  | 0.00      | 0.00    | QC8 3RD 612           |           |          |
| 130   | Packaging          | 80 pcs |            | 12/3/17  | 0.00      | 0.00    | Packaging3 L6001      |           |          |
| 140   | QC21-SA            | 80 Ea  |            | 12/3/17  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - 1-TURN AS PER FOLIO FA628 & DWG D3490

Descriptions: 130 - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER

DEC 08 2017

### Job Allocations

| Operation             | Component Part     | Required | Inventory | Allocated | Std Qty |
|-----------------------|--------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | M6061T6T0.500W.049 | 21       | 46        | 0         | 0       |

FM 31932 = 24

### Part Specifications

| Spec No | Description      | Target/Tolerance               | Limits         | Type | Special Comments |
|---------|------------------|--------------------------------|----------------|------|------------------|
| 1       | Crossbolt Spacer | 0.500inches + 0.006<br>- 0.001 | 0.506<br>0.499 |      |                  |
| 2       | Crossbolt Spacer | 0.049inches ± 0.010            | 0.059<br>0.039 |      |                  |
| 3       | Crossbolt Spacer | 0.402inches + 0.006<br>- 0.001 | 0.408<br>0.401 |      |                  |
| 4       | Crossbolt Spacer | 3.085inches + 0.030<br>- 0.000 | 3.115<br>3.085 |      |                  |
| 5       | Crossbolt Spacer | 0.050inches ± 0.010            | 0.060<br>0.040 |      |                  |
| 6       | Crossbolt Spacer | 45Degrees ± 0                  | 45<br>45       |      |                  |

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Plex 11/21/17 7:43 AM dart.lacelle.linda